


# Work Order ID 76138

**\*76138\***

Page 1

Monday, November 07, 2011 11:12:20 AM

Item ID: D2666-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, RH Fwd Aft In 206  
 Start Date: 11/7/2011 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 11/16/2011 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan:  Date: 11/11/07 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2666	Rev D								
100	HAAS CNC VERTICAL MACHINING #1	0.00							
<b>*100*</b>									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Program batch number.1-Inspect part number and batch number are programmed correctly.4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 6								
110	CONVENTIONAL MILLING MACHINE	0.00							
<b>*110*</b>									
Mill Conv	Memo	0.00							
Conventional Milling Machine	Machine Keyway and inspect per attached dimension sheet								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

F.K. 12/03/23

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Monday, November 07, 2011 11:12:20 AM

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 Required Date: 11/16/2011 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	B.A	12/03/24		4	0		
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				4	BR	12/03/26	
150 <b>*150*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo START TIME: 11h25 11h55 FINISH TIME: _____	0.00  0.00				4	Q	DP 12/03/26	

m120222

OVEN TEMPERATURE:

320°F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 76138

**\*76138\***

Page 3

Monday, November 07, 2011 11:12:20 AM

Item ID: D2666-2

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Saddle, RH Fwd Aft In 206

Start Date: 11/7/2011 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 11/16/2011 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

4 6 M n(0.1)20

170

Identify as per dwg & Stock Location: 426

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

12/3/29 40 P

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/4/29 J

01203-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, November 07, 2011 11:12:25 AM

Page 1

Work Order ID: 76138

**\*76138\***

Parent Item: D2666-2

**\*D2666-2\***

Parent Item Name: Saddle, RH Fwd Aft In 206

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house processEC  
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	162.0000	1	4			

**\*D6101-001\***

Saddle Billet

**\*\***

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	162	
66965	1	
69677	2	
73774	60	
74648	31	
74679	68	

80764

4 FK- 12/03/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	76136
<b>Description:</b> 206 Saddle, Inboard, Right side	<b>Part Number:</b>	D2666-2
<b>Inspection Dwg:</b> D2666 Rev. D		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.123	.123	.123	.123		
B	0.100	0.140		.123	.124	.123	.123		
C	2.470	2.510		2.493	2.493	2.492	2.492		
D	0.100	0.180		.135	.135	.135	.135		
E	0.210	0.230		.222	.222	.222	.222		
F	1.313	1.343		1.325	1.325	1.325	1.325		
G	0.240	0.260		.250	.250	.250	.250		
H	0.615	0.685		.650	.650	.650	.650		
I	1.125	1.145		1.135	1.135	1.135	1.1345		
J	0.990	1.010		1.002	1.002	1.002	1.002		
K	0.235	0.240		.237	.237	.237	.237		
L	0.510	0.515		.512	.512	.512	.512		
M	0.100	0.120		.112	.112	.112	.112		
N	1.565	1.585		1.575	1.575	1.5755	1.5745		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.490	0.510		.500	.498	.499	.499		
S	0.313	0.318		.314	.314	.314	.314		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.315	0.322		.316	.316	.316	.316		
W	0.540	0.560		.550	.550	.550	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.260	.260	.260	.260		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	FK
Date:	12/03/23

Audited by:	DA
Date:	12/03/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

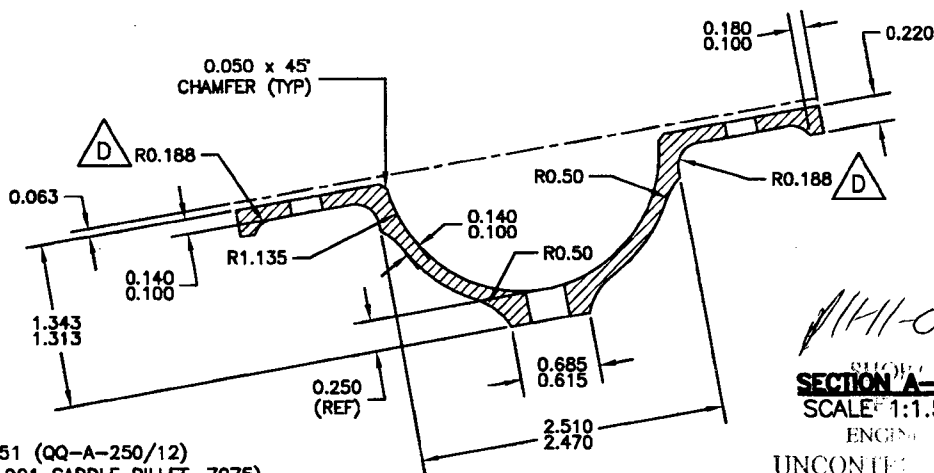
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**DART**

DESIGN <b>#</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <b>PH</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08		TITLE SADDLE FWD INSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	

RELEASED

07-02-12 **#**SECTION A-A  
SCALE 1:1.5

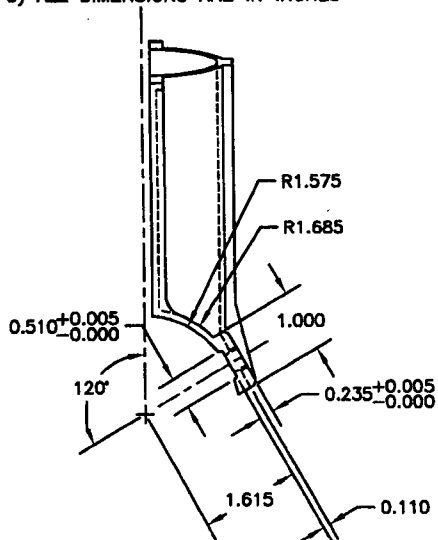
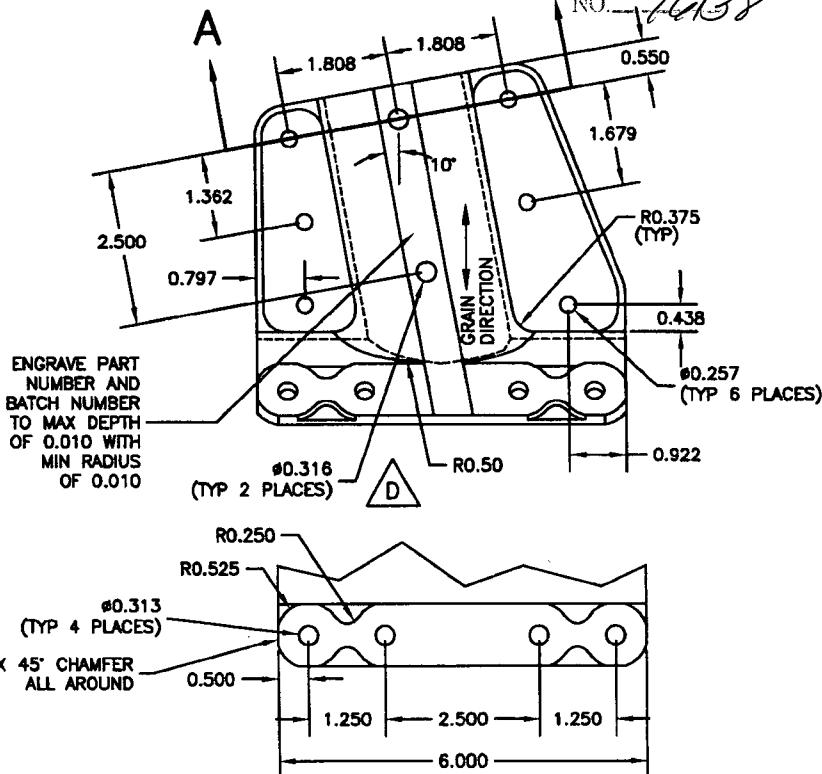
UNCONTROLLED

SUBJECT TO CHANGE

WITH THE WORK

NO. 76138

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
  - 6) ALL DIMENSIONS ARE IN INCHES

**D2666-1 SADDLE FWD INSIDE HIGH**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries